

Work Order ID 148718

Wednesday, July 06, 2016 8:44:07 AM

148718

Page 1

Item ID: D2673-34 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: End Plate
Start Date: 8/10/2016 Start Qty: 24.00 ***24*** Cust Item ID:
Required Date: 8/12/2016 Req'd Qty: 24.00 ***24*** Customer:
Reference:

Approvals: Process Plan: **DAS 21** Date: **JUL 11 2016** Tooling: Date: Run Start ***NR1***
QC: **9-89** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2673	Rev B

100

0.02

100

FLOW WATER JET

Waterjet

Memo

0.08

FLOW CNC Waterjet

1-Cut as per Dwg D2673 Dwg Rev: **B** Prog Rev: **B** 2-
Deburr if necessary**(34)****De 16/08/14**

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.04

Quality Control

(34)**De 16/08/14**

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.08

Quality Control

(34)**DAS
38
9-89****AUG 15 2016**

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

148718

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

24

Cust Item ID:

24

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

Identify as per dwg & Stock Location:

0.00

130

Packaging

Packaging

Memo
LOCATION WA003

0.04

DAS
6
9-89

Cont
34

P.

AUG 15 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.40

**DAS
21
9-89**

AUG 16 2016

**DAS
21
9-89**

AUG 16 2016

DQA: _____ Date: _____

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QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Wednesday, July 06, 2016 8:44:06 AM

Page 1

Work Order ID: 148718

148718

Parent Item: D2673-34

D2673-34

Parent Item Name: End Plate

Start Date: 8/10/2016

Required Date: 8/12/2016

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP C02.01.14Removed deburr and inspect level 5NG/EC
IPP Rev:D Now 6061-T6 06-06-23 JLM
IPP Rev:C Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		100	sf	278.7000	0.052	1.313683			

M6061T6S 080

6061-T6 .080 Sheet

06/08/16

Location

Loc Qty

Loc Code

MAT020

278.7

134217

16.1

m132772

4.3

m133587

7.7

m133828

4.9

m134551

9.3

m134696

112

m134830

28.4

m135147

96

2.2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
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OTHER : _____					

DART AEROSPACE LTD		Work Order:	148718
Description: End Plate		Part Number:	D2673-34
Inspection Dwg: D2673	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

Prototype

[illegible]

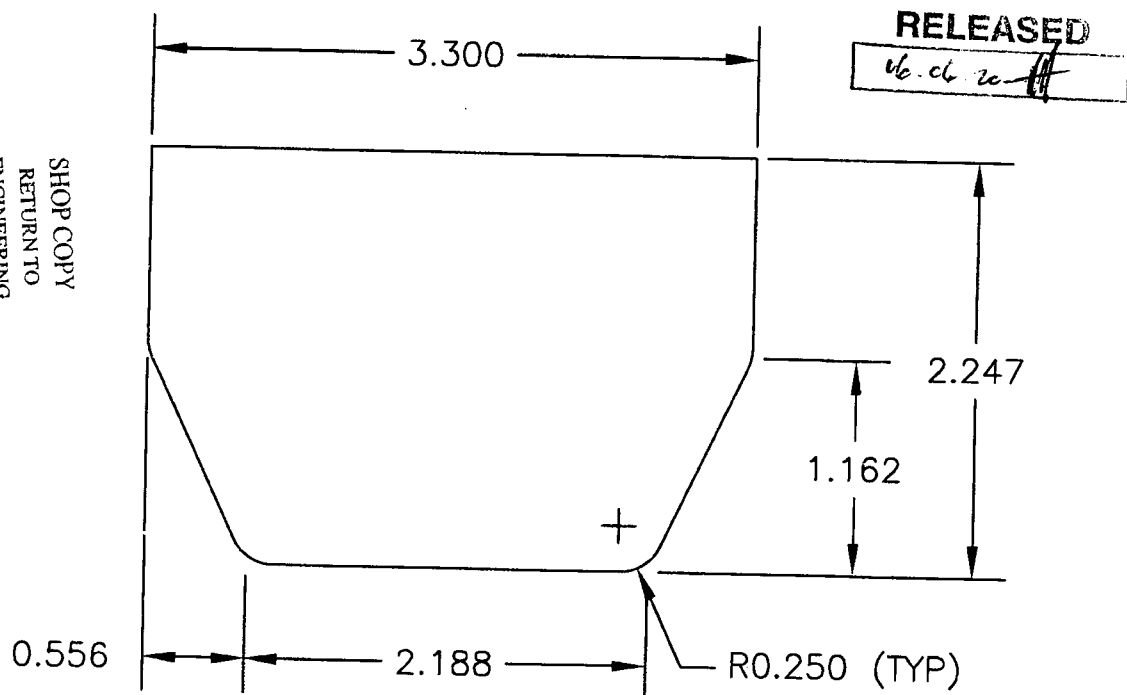
Measured by:	<i>du</i>	Audited by:	DAS 38	Prototype Approval:	N/A
Date:	16/08/17	Date:	15/09/2016	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue	KJ/RF	
B	04.06.15	Remove 1.162, 2.188 & 0.556 dimensions	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D2673	REV. B SHEET 1 OF 1
DATE 06.05.29	TITLE END PLATE SCALE 1:1		
A	97.05.06	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

END PLATE FOR D2244 EXTRUSION CUT AT 34°

D2673-34**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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